

Date: Wednesday, 4/4/2007 9:03:35 AM
 User: Kim Johnston

Process Sheet

Customer	CU-DAR001 Dart Helicopters Services	Drawing Name	: LUG
Job Number	31609A		
Estimate Number	10839		
P.O. Number	N/A	Part Number	: D22491
This Issue	4/4/2007	Drawing Number	: D2249 REV. E
Prsht Rev.	NC	Project Number	: N/A
First Issue	N/A	Drawing Revision	: E
Previous Run	31502	Material	: N/A
Written By		Due Date	: 4/11/2007
Checked & Approved By	<u>4/4/07,04/04</u>	Qty:	10
Comment	Est: D 05.02.04 Added Step 9 KJ/RF Est Rev:E Now on Waterjet 07-03-08 JLM	Um:	Each

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet
Comment: Qty.: 0.0903 sf(s)/Unit Total : 0.9030 sf(s) 304/316 .063 Sheet Batch: <u>N103961</u> SAD 07/04/14		
2.0	WATER JET	FLOW WATER JET
Comment: FLOW WATER JET 1-Cut as per Dwg D2249 Dwg Rev: <u>E</u> Prog Rev: <u>E</u>		
		 <u>07/04/14</u> 10 SAD 07/04/14
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE SAD 07/04/14		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK 07/04/14 10		
5.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>15</u> PD 07-06-25 10		

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: Date: 01/06/09
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/4/2007 9:03:35 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LUG

Job Number: 31609A

Part Number: D22491

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



(P)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4/4/07

Job Completion



4/4/07

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	31609A
Description: Lug	Part Number:	D2249-1
Inspection Dwg: D2249	Rev: E	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	SAN	Audited by:	DA	Prototype Approval:	N/A
Date:	07/04/18	Date:	07/04/18	Date:	N/A

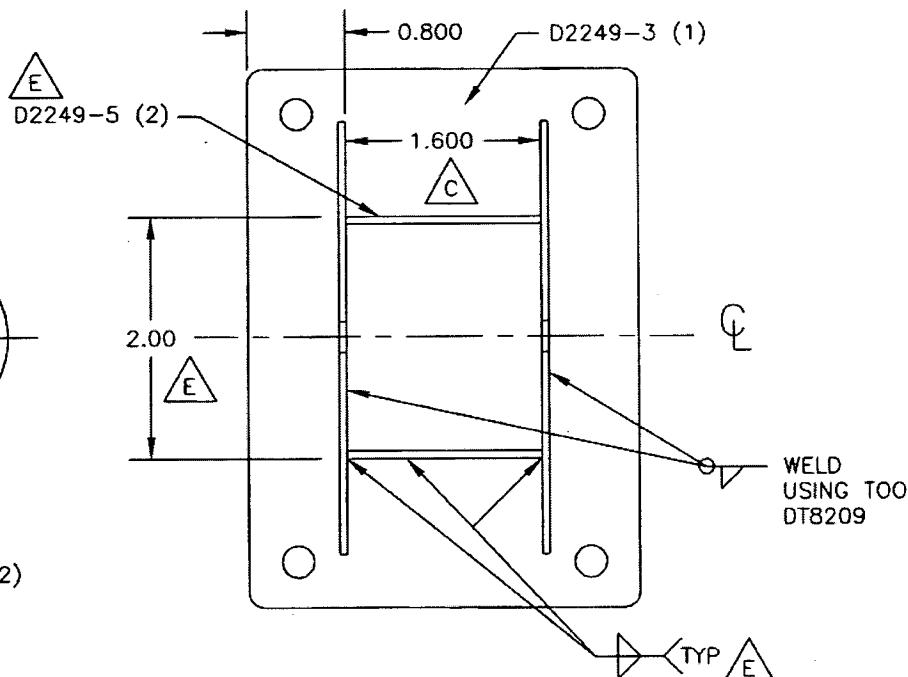
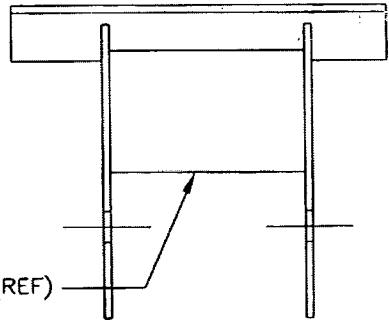
Rev	Date	Change	Revised by	Approved
A	07.03.23	New Issue	KJ/JLM	JL

DART**RELEASED**
94.10.12
KE

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>KE</i>	APPROVED <i>RF</i>	DRAWING NO. D2249
DATE 99.09.20	REV. E	REV. E
	SHEET 1 OF 4	SHEET 1 OF 4
	SCALE NTS	SCALE NTS

A	94.06.20	NEW ISSUE
B	95.11.30	DIMENSION CHANGE
C	95.12.14	DIMENSION CHANGE
D	98.04.30	$\phi 0.261$ WAS $\phi 0.257$ (TSR A179) REMOVED DUPLICATE DIMENSIONS

E	99.09.20	ADDED GUSSET
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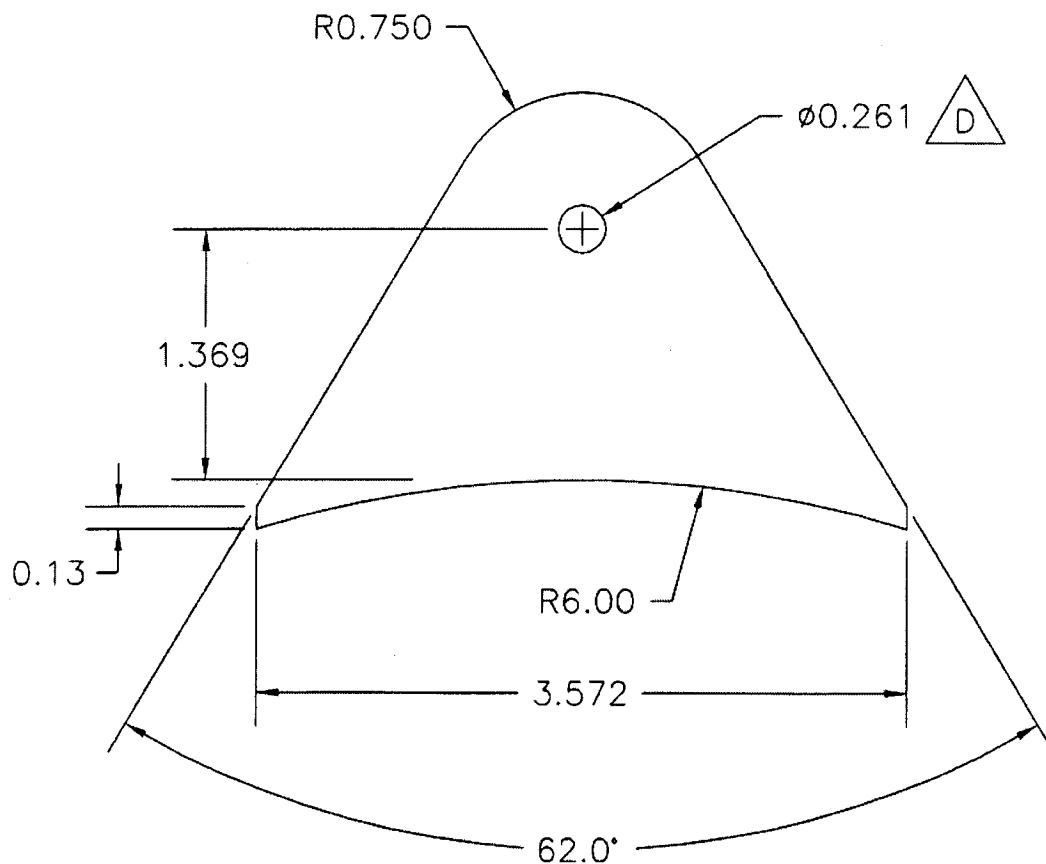
D2249-041 ASSEMBLY

MATERIAL: AISI 304/316 SS, 0.063 THICK
WELD PER DART QSI 004
FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE SPECIFIED

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WORK ORDER
NO. 31609A

DART

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CHECKED <i>KE</i>	APPROVED <i>RF</i>	DRAWING NO. D2249
DATE 99.09.20	TITLE FITTING	REV. E SHEET 2 OF 4 SCALE 1:1

RELEASED
99.10.12 KED2249-1 LUG

MATERIAL: AISI 304/316 SS 0.063 THICK
ALL DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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TO

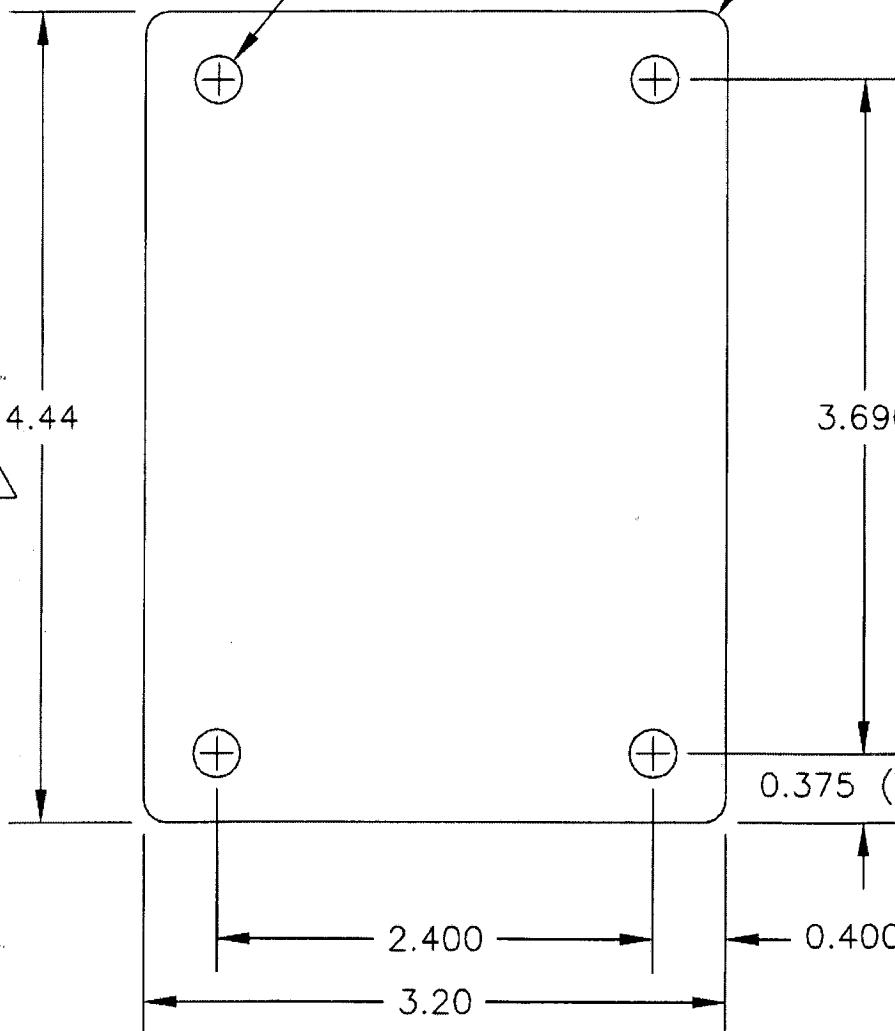
DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>KE</i>	APPROVED <i>W</i>	DRAWING NO. D2249
DATE 99.09.20		TITLE FITTING

REV. E

SHEET 3 OF 4

SCALE

1:1

RELEASED
*99.10.12 KE*Φ0.261 (TYP)  R0.125 (TYP)FLAT PATTERND2249-3 BASE PLATE

MATERIAL: AISI 304/316 SS 0.063 THICK

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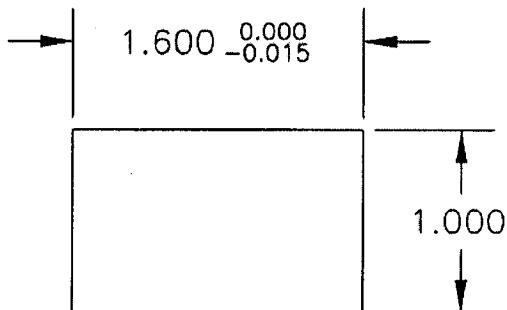
DART

COPY ISSUED

DESIGN <i>KE</i>	DRAWN BY <i>RF</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>KE</i>	APPROVED <i>RF</i>	DRAWING NO. D2249	REV. E SHEET 4 OF 4
DATE 99.09.20		TITLE FITTING	SCALE 1:1

RELEASED

49.10.12 KE

D2249-5 GUSSET

MATERIAL: AISI 304/316 SS 0.063 THICK

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